

## ABSTRACT OF THE DISCLOSURE

A hole forming tool has a main body constructed of a cemented carbide comprising  $10 \pm 2$  wt% Co,  $0.65 \pm 0.25$  wt% Cr, WC for the balance, and inevitable impurities. The average particle diameter of WC is in the range of 0.1 to  $1.0 \mu\text{m}$ , and a radial rake angle of cutting edges formed at the end of the hole forming tool is set to a negative value in the range of  $-5^\circ$  to  $-10^\circ$ . Chip discharging grooves of which the helix angle is in the range of  $5^\circ$  to  $15^\circ$  are formed in the exterior surface of the hole forming tool. A groove width ratio of land portions and the chip discharging grooves is in the range of 0.9 to 1.1. A point angle is in the range of  $125^\circ$  to  $135^\circ$ , and a core diameter is in the range of  $0.38D$  to  $0.42D$ , in which  $D$  is the outside diameter of the drill. The main body of the hole forming tool is coated with a TiAlN layer.

I:\atty\JDH\0834\205279US.spec.wpd